

Date: Thursday, 07/02/2008 11:11:40 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 37292 *3*
 Estimate Number : 12712
 P.O. Number :
 This Issue : 07/02/2008 S.O. No. :
 Prsh Rev. : NC
 First Issue : // Type : SMALL /MED FAB
 Previous Run : 36714
 Written By :
 Checked & Approved By :
 Comment : Est Rev A New Issue 07-02-14 JLM

Drawing Name : WEARPAD
 Part Number : D35371
 Drawing Number : D3537 REV C
 Project Number : NA
 Drawing Revision : C
 Material :
 Due Date : 28/02/2008 Qty: 100 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	M304S16GA	304/316 .063 Sheet
	Comment: Qty.: 0.1113 sf(s)/Unit Total: 11.1300 sf(s) M304S16GA .063" 304 SS SHEET Batch: 106860	
2.0	WATER JET	FLOW WATER JET
	Comment: FLOW WATER JET 1-Cut as per Dwg D3537 Dwg Rev: <i>C</i> Prog Rev: <i>C</i>	
	2-Deburr if necessary	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	
5.0	BRAKE NC	NC BRAKE
	Comment: NC BRAKE 1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326. 2-Identify as D3537-1	 <i>✓ 08/02/12</i> <i>*125</i>



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Description :

6.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch M107051

A/R 2059B Hardcoat M106834 SP

1-Weld as per Dwg D3537 using Jig DT 8210

2-Remove any weld that penetrated through Wearpadif necessary

MF

08-03-27

(40x)

7.0 QC7/0

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

DO 080327 / EO 08/03/27

(40)

8.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

EO 08/03/27 (x40)

9.0 POWDER COATING

POWDER COATING



M106442

(40x)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M-1 08/03/29

10.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION

MF



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-03-31

(40)

11.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FN-20

MF

08-03-31 (40)

12.0 QC21

FINAL INSPECTION/W/O RELEASE



08/04/02

Comment: FINAL INSPECTION/W/O RELEASE

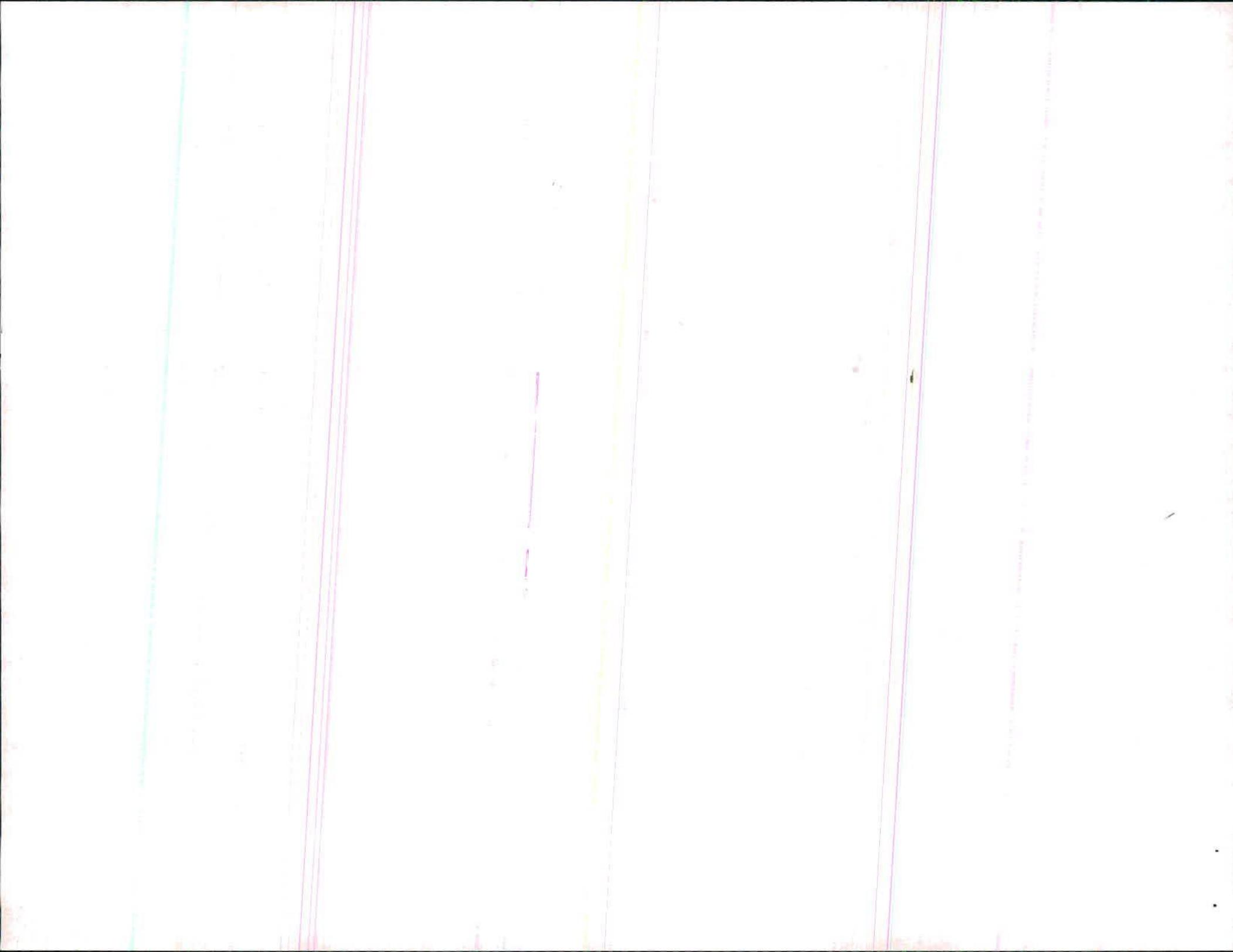
Job Completion



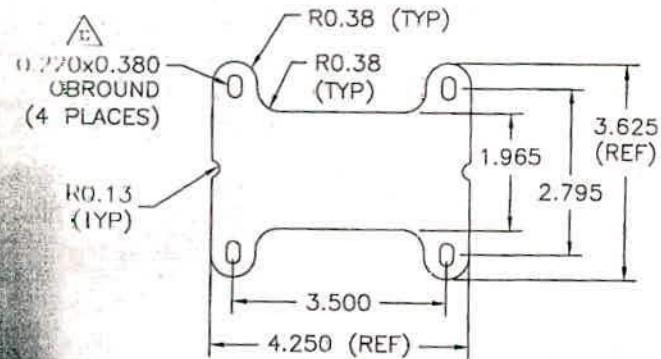
MF

08-03-31

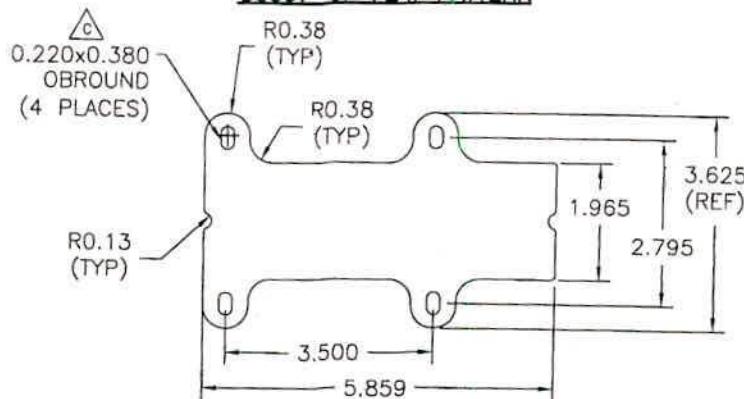
W



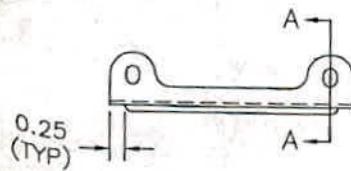
D3537-1F FLAT PATTERN



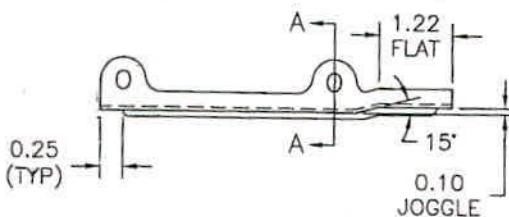
D3537-3F FLAT PATTERN



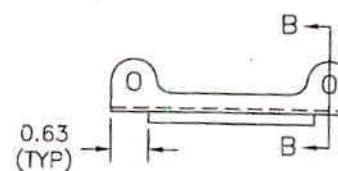
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



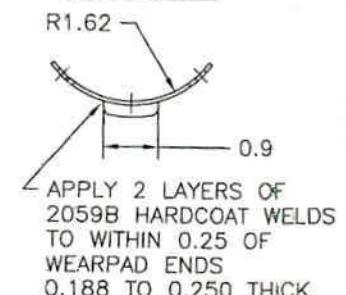
D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



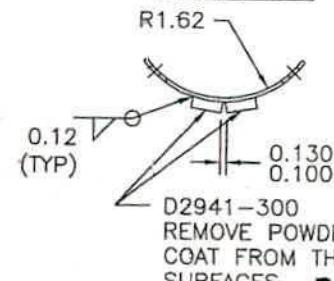
D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



SECTION A-A

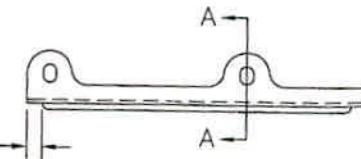


SECTION B-B



RELEASED
07.05.08 AM
per E&N

D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DART AEROSPACE USA, INC.

DESIGN	CB	DRAWN BY	PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	<input checked="" type="checkbox"/>	APPROVED	<input checked="" type="checkbox"/>	DRAWING NO. D3537
DATE	07.04.13	TITLE	WEARPAD	REV. C SCALE 1:2



DART AEROSPACE LTD	Work Order:	37292
Description: WEAR PAD	Part Number:	D3537-1
Inspection Dwg: D 3537-1 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: 4B	Audited by: C	Prototype Approval: N
Date: 8-2-12	Date: 28/4/12	Date: 17

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

